










Date: Tuesday, 27/01/2009 11:13:42 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW INSTALLATION KIT (48")
Job Number	: 45287		
Estimate Number	: 12620		
P.O. Number	:	Part Number	: D430688011
This Issue	: 27/01/2009 S.O. No. :	Drawing Number	: D2521
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 27/01/2009 Type : MACHINED PARTS	Drawing Revision	: J
Previous Run	:	Material	:
Written By	:	Due Date	: 15/02/2009 Qty: 2 Um: Each
Checked & Approved By	: <u>JLD 09.01.27</u>		
Comment	: Est Rev:A New Issue 07-01-03 JLM Est Rev:I 08-10-01 New Manufacturing Method JLM Verified By:EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
		<u>HJ for JLD 09/02/18</u>	
Comment: DOCUMENT CONTROL Photocopy blue file and type labels per PPP D430-688-011 CHG003			
2.0	MUHMWB10	UHMW 1" Black	
			
Comment: Qty.: 8.4000 sf(s)/Unit Total : 16.8000 sf(s) blank: 19.500" x 48.0" x 1.00" thick (+0.030/-0.000) per DSK086-6 Material: Black UHMW 1" (MUHMWB10) Batch: <u>110721</u> <u>B 9-2-7</u> 4			
3.0	WATER JET	FLOW WATER JET	
		<u>B 9-2-7</u>	
Comment: FLOW WATER JET Cut Blank as per D2521 blank file			
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
Comment: HAAS CNC VERTICAL MACHINING #1 (2) Bearpaws Make (1) kit 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2521 Identify as D2521 3-Deburr			
<u>J.L 09/02/12</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 27/01/2009 11:13:42 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW INSTALLATION KIT (48")

Job Number: 45287

Part Number: D430688011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JI 09/02/12

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SF 09/02/13 (4)

7.0

D2182B

Rubber Cushion



Comment: Qty.: 3.7000 f(s)/Unit Total: 7.4000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2182B055 Rubber Cushion

42737

SS 09/02/17 (x2)

8.0

D2274

Radius Block



Comment: Qty.: 16.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 D2274 Radius Block

B43838

SS 09/02/17 (x2)

9.0

D2529

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 D2529 Washer

42408

SS 09/02/17 (x2)

10.0

D2947

Clamp



Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)

Clamp

Pick:

Qty Part Number Description Batch

8 D2947 Clamp

44049

SS 09/02/17 (x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 27/01/2009 11:13:42 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW INSTALLATION KIT (48")

Job Number: 45287

Part Number: D430688011

Job Number:



Seq. #: Machine Or Operation: Description :

11.0 AN415A Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN4-15A Bolt M110399

SS 09/02/17 (X2)

12.0 AN960JD416 Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416 Washer M110523

SS 09/02/17 (X2)

13.0 MS21042L4 Nut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Nut

Batch: M109282

SS 09/02/17 (X2)

14.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

09-02-19 (2)

15.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D430-688-011

Location: 34

PPP Rev: A

9/2/10

SL

(2)

16.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/2009

Job Completion



MF
09-02-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 45287
Description: Bearpaw		Part Number: D2521
Inspection Dwg: D2521 Rev: J		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	.260	✓			
B	0.90	0.96	.925	✓			
C	0.27	0.330	.315	✓			
D	0.470	0.530	.500	✓			
E	21.740	21.760	21.750	✓			
F	0.72	0.780	.750	✓			
G	0.35	0.410	.380	✓			
H	11.490	11.570	11.500	✓			
I	3.41	3.47	3.435	✓			
J	11.790	11.810	11.800	✓			
K	9.47	9.53	9.500	✓			
L	7.190	7.210	7.200	✓			
M	6.910	6.970	6.940	✓			
N	44.47	44.530	44.500	✓			
O	6.590	6.650	6.618	✓			
P	0.940	0.980	.956	✓			
Q	18.97	19.03	19.00	✓			
R	0.350	0.410	.380	✓			
S	0.740	0.780	.750	✓			
T	0.240	0.280	.245	✓			
U	0.370	0.410	.381	✓			
V	0.740	0.780	.750	✓			
W	0.740	0.780	.754	✓			

Measured by: J.L	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 09/02/11	Date: 09/02/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



DESIGN	<i>th</i>	DRAWN BY	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>CP</i>	APPROVED	<i>th</i>	DRAWING NO.	REV. J
				D2521	SHEET 1 OF 3
DATE	06.07.28			TITLE	SCALE
				205 BEARPAW	NTS
A	95.11.28	NEW ISSUE			
B	96.01.11	SHOW BENDING MOVE HOLES			
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING			
D	96.05.14	ADJUSTED BEAR PAW THICKNESS			
E	96.12.18	43.500 WAS 46.750			
F	97.05.07	ADDED REAR POCKET, MOVED HOLES			
G	98.08.06	ADD C'BORE AND CHAMFER EDGES			
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.			
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES			
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE			

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WORK ORDER
NO. *45287*

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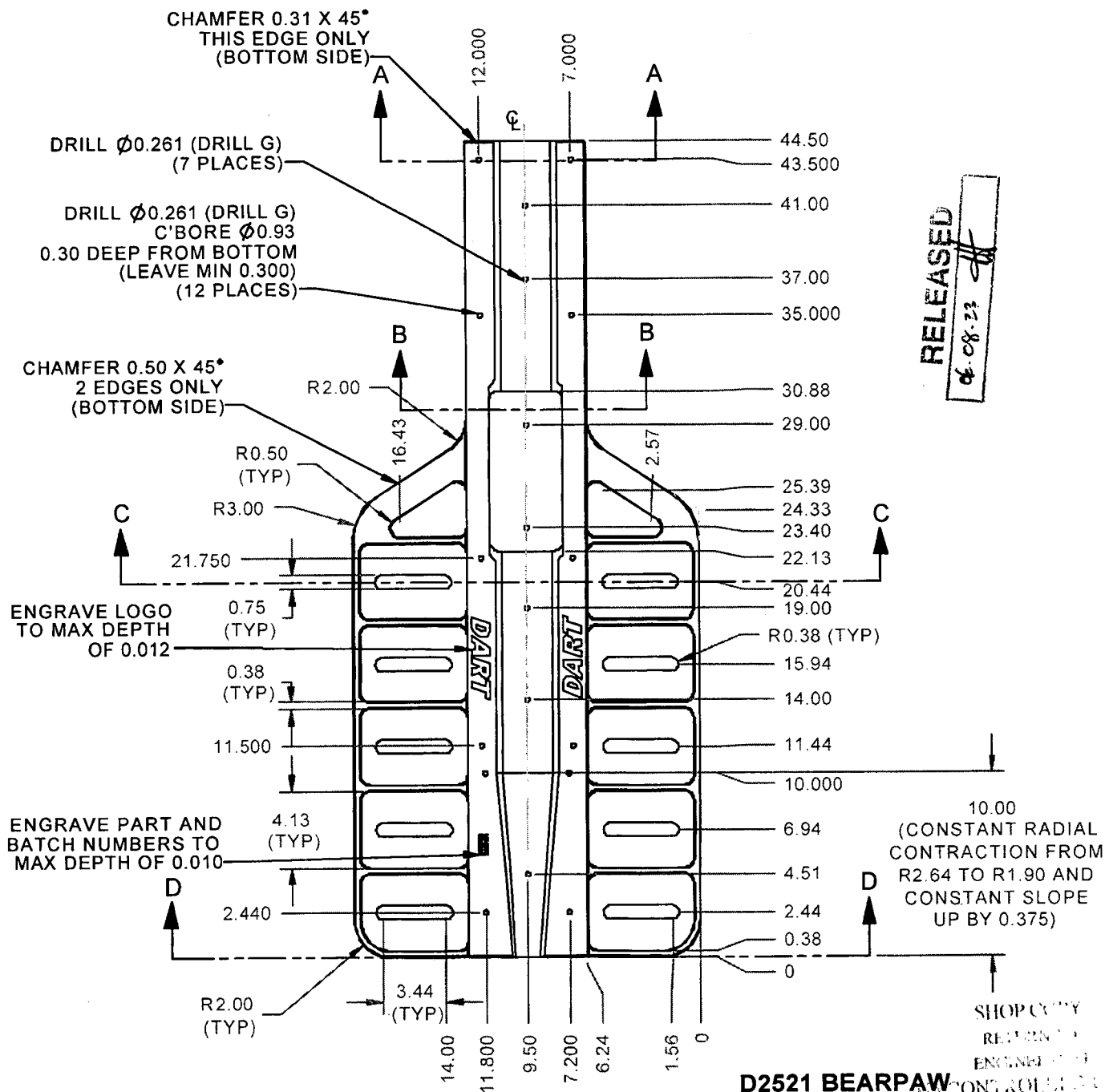
06 08 23 *th*

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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. J
		D2521	SHEET 2 OF 3
DATE	TITLE		SCALE
06.07.28	205 BEARPAW		1:8

**NOTES:**

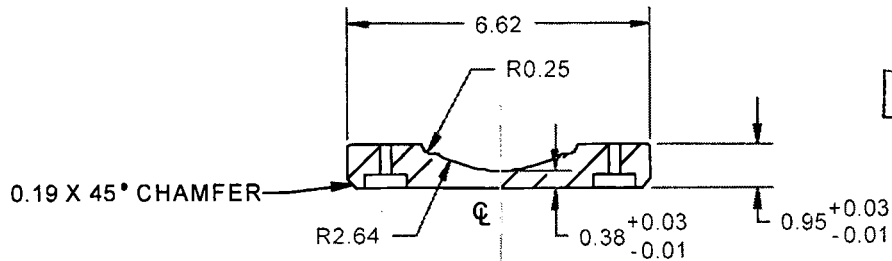
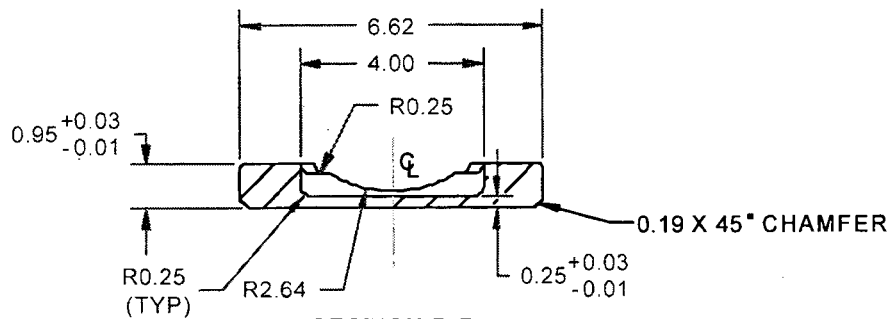
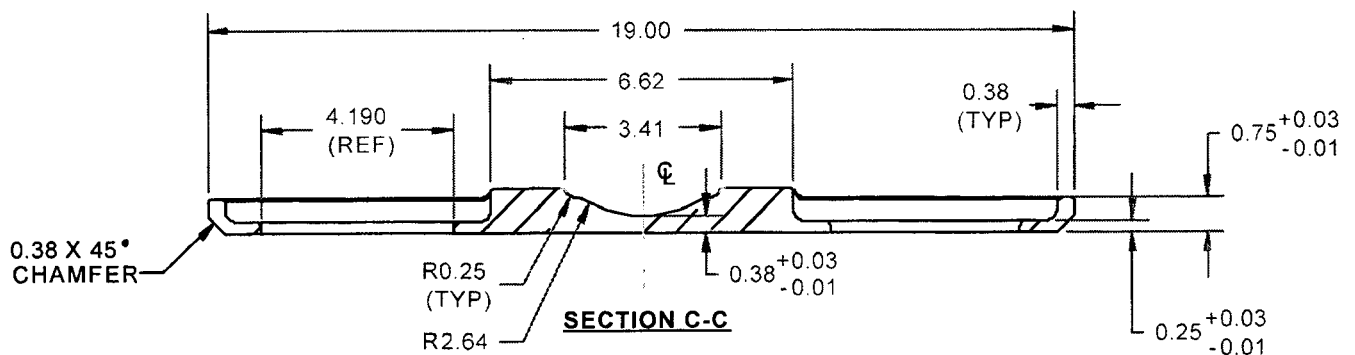
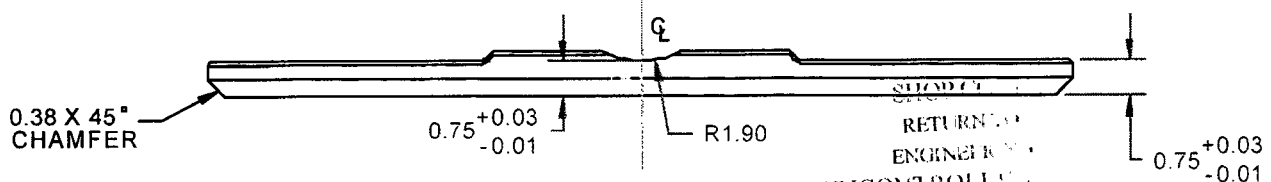
- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
- 6) PART IS SYMMETRIC ABOUT \varnothing

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DART

DESIGN #	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED [Signature]	DRAWING NO. D2521	REV. J
DATE 06.07.28	TITLE 205 BEARPAW	SHEET 3 OF 3	
		SCALE 1:4	

**SECTION A-A****SECTION B-B****SECTION C-C****SECTION D-D**

RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO APPROVAL
WITHOUT NO
WORK
NO. 45287

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